

Work Order ID 51757

September 2, 2009 9:55:29 AM



Page 1

Item ID: D2594-1

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plug, 205 Skidtube

Start Date: 03/09/2009 Start Qty: 906.00

Cust Item ID:

Required Date: 22/09/2009 Req'd Qty: 906.00

Customer:

Reference:

09-08-02

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2594	Rev C

100

0.00



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.

*2 Nov 07/03
DTP 09/09/02*

841

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

*2 Nov 07/03
DTP 09/09/02*

841

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Y.A 09/09/08

841

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Item ID: D2594-1

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Setup Start



Revision ID: C

Stop



Item Name: Plug, 205 Skidtube

Start Date: 03/09/2009 Start Qty: 906.00



Cust Item ID:

Required Date: 22/09/2009 Req'd Qty: 906.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MO 09/09/08

84/

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:00pm ☐ OVEN TEMPERATURE:

3:30pm ☐ FINISH TIME: 4:00pm

24 09/09/08

84/

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK

09-09-9






84/

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Item ID: D2594-1 Accept  Setup Start 
Revision ID: C Stop 
Item Name: Plug, 205 Skidtube
Start Date: 03/09/2009 Start Qty: 906.00  Cust Item ID:
Required Date: 22/09/2009 Req'd Qty: 906.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <i>F2A</i>	0.00	<i>BL 09-09-9</i>	<i>(S41)</i>					
Packaging	Memo	0.00							
Packaging									
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/09/01 *(Signature)*
mc *09-09-10*

Picklist Print

Page 1

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Parent Item: D2594-1RevC



Parent Item Name: Plug, 205 Skidtube

Start Date: 03/09/2009

Required Date: 22/09/2009

Start Qty: 906.00

Required Qty: 906.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.625		Purchased	No			110	f	83.8100	49.6869			
6061-T6 Round Bar .625"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

83.81

109733

5.72

110250

18.09

111650

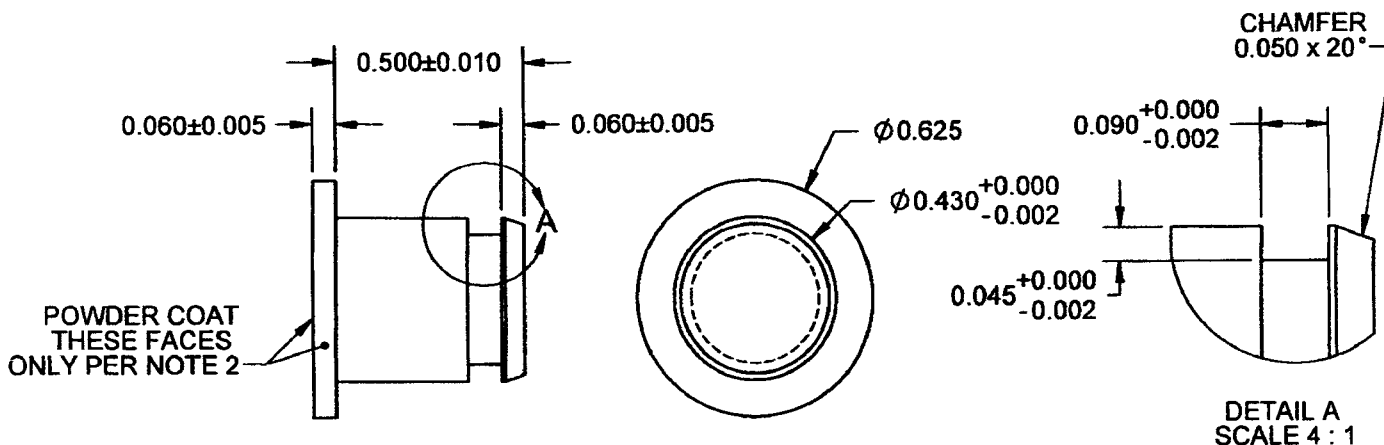
60

6.3 SA 09/09/04
39.9 DIP 09/09/02



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG SCALE 2:1	
REV	DATE	DESCRIPTION	
A	96.09.16	NEW ISSUE	
B	97.03.15	ADD GROOVE AND O-RING	
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE	

RELEASED
06.11.28



D2594-1 PLUG

D2594-1 PLUG NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3 \triangle
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

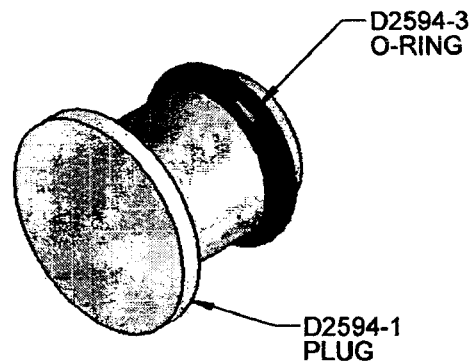
D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011 \triangle

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING

51757



D2594 PLUG ASSEMBLY

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